

# Work Order ID 58022

April 21, 2010 3:59:21 PM



Page 1

Item ID: D4095-1	Accept		Setup	Start	
Revision ID: PRELIM					
Item Name: Wearplate				Stop	
Start Date: 21/04/2010	Start Qty: 1.00				
Required Date: 28/04/2010	Req'd Qty: 1.00				
Reference:					

Approvals:	Process Plan: <u>11</u>	Date: <u>10-4-21</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4095	<u>PA2</u> <u>10.04.22</u>								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4095 Dwg Rev: <u>PA2</u> Prog Rev: <u>PA2</u> 2-Deburr if necessary								②
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

→ 81061/23 x2  
to PA2 Dwg only

**QC APPROVAL**

**PRELIMINARY ISSUE**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




# Work Order ID 58022

April 21, 2010 3:59:21 PM

Page 2

Item ID:	D4095-1	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Wearplate					
Start Date:	21/04/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	28/04/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	1- bend section C-C first 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Ensure joggle as per dwg D4095								
150 	Weld per dwg A/R Hardcoat S.S. Batch: _____	0.00							
Large Fab	Large Fab								
Large Fab	Memo	0.00							
	same template as D3564-1-3								

Sp 10/04/23

QC APPROVAL

→ Rto in skid tube  
Rt is Rto  
Rt is Rto

Sidark3 x2  
to P2 only

EL 10-4-23 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 58022

April 21, 2010 3:59:21 PM



Page 3

Item ID: D4095-1	Accept		Setup	Start	
Revision ID: PRELIM				Stop	
Item Name: Wearplate					
Start Date: 21/04/2010	Start Qty: 1.00		Cust Item ID:		
Required Date: 28/04/2010	Req'd Qty: 1.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00							
170  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							
180  Powdercoat Powder Coating	Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3  Memo START TIME: 1:45pm OVEN TEMPERATURE: 320°C FINISH TIME: 1:45pm	0.00  0.00							

*See Serial 123*

*→ take on ship. They are tight!  
→ inspect to PA2 Dwg only 10/14/23 re*

**QC APPROVAL**

*⇒ 10/10/26*

*x2*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April 21, 2010 3:59:25 PM

Page 1

Work Order ID: 58022



Parent Item: D4095-1



Parent Item Name: Wearplate



Start Date: 21/04/2010

Required Date: 28/04/2010

Comments: IPP Rev:A new issue DD 10.04.21 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	0.0000	2.3076 			

B 10-4-22

304 .063 114467

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 58022
Description: WEAR PLATE		Part Number: D4095-1
Inspection Dwg: D4095-1, Rev: PA2		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

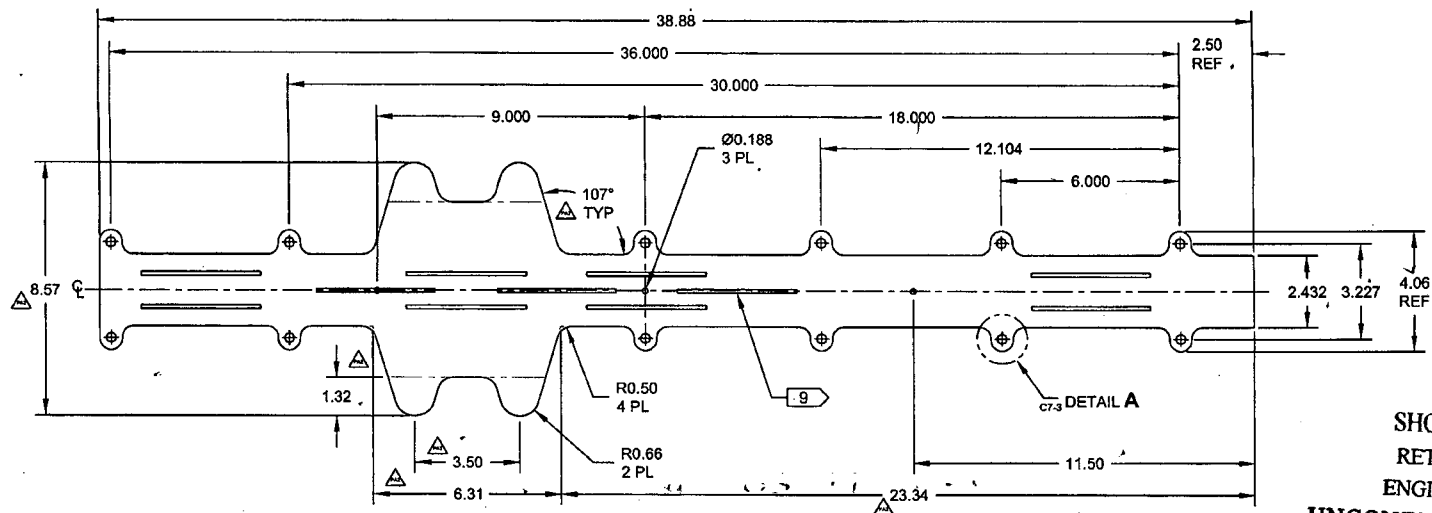
Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1300	+/- .010	1302	✓			
300	+/- .010	303	✓			
2.432	+/- .010	2.432	✓			
3.227	+/- .010	3.224	✓			
4.06	+/- .030	4.055	✓			
2.50	+/- .030	2.502	✓			
11.50	+/- .030	11.50	✓			
23.34	+/- .030	23.34	✓			
6.31	+/- .030	6.31	✓			
3.50	+/- .030	3.50	✓			
1.32	+/- .030	1.333	✓			
8.57	+/- .030	8.568	✓			
6.000	+/- .010	5.997	✓			
12.104	+/- .010	12.104	✓			
18.000	+/- .010	18.000	✓			
9.000	+/- .010	9.000	✓			
30.000	+/- .010	30.000	✓			
36.000	+/- .010	36.000	✓			
38.88	+/- .030	38.875	✓			
Ø .188	+ .005 - .001	.189	✓			
.063	+/- .010	.059	✓			

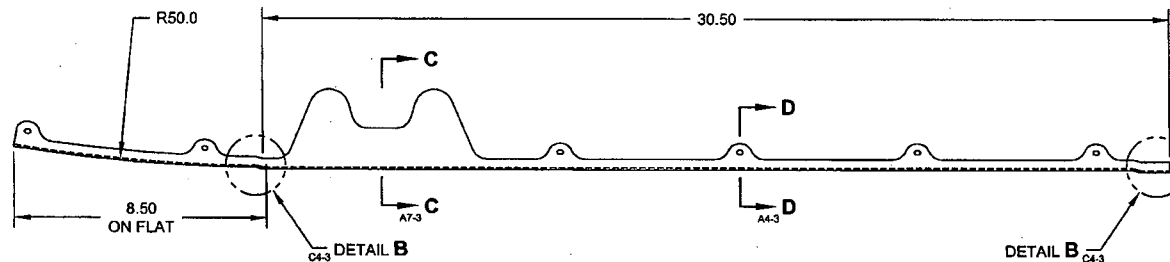
Measured by: RB	Audited by: S	Prototype Approval:
Date: 10-4-22	Date: 10/04/23	Date:

to PA3 Duty only

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D4095-1F FLAT PATTERN** 1



**D4095-1 BENDING DETAIL**  
(MAKE FROM D4095-1F)

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240  
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-X" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4095-1 = 2.18 lbs; D4095-3 = 2.16 lbs
- 8) WELDING: PER DART QSI 004
- 9) 2059B HARDCOAT WELD: 4.0 LONG X 0.063 TO 0.125 HIGH, 11 PL  
WELD AFTER BENDING AS ILLUSTRATED PER DT8308

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 58022

10.04.22

PRELIMINARY ISSUE  
10.04.22

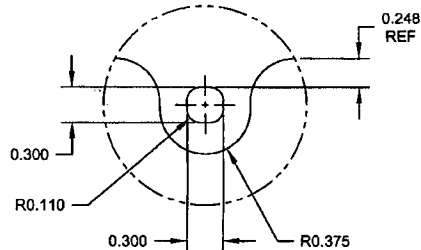
PA2	ADDED CLEARANCE FOR INSIDE SADDLE INCREASED EDGE DISTANCE ON SAME PROFILE	MB	10.04.22
PA1	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.22		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4095  
REV. PA2  
SHEET 1 OF 3

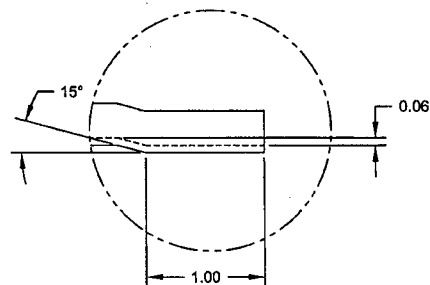
TITLE WEARPLATE  
SCALE NTS

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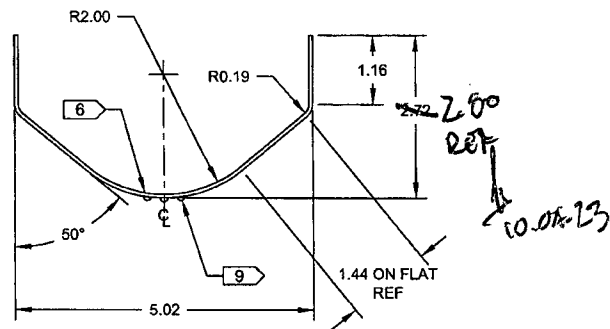
**DETAIL A: TAB DETAIL**

SCALE 4X  
C3-1  
C6-2



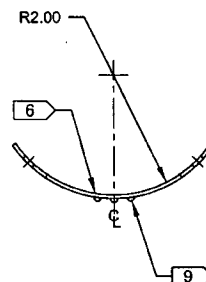
**DETAIL B: JOGGLE DETAIL**

SCALE 4X  
B2-1  
B6-1  
B4-2  
B7-2



**SECTION C-C**

SCALE 2X  
B5-1  
B4-2



**SECTION D-D**

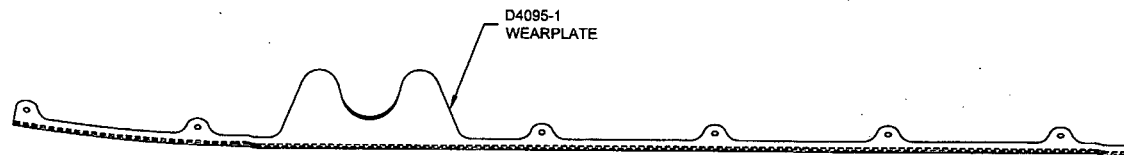
SCALE 2X

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 58022  
10.04.22

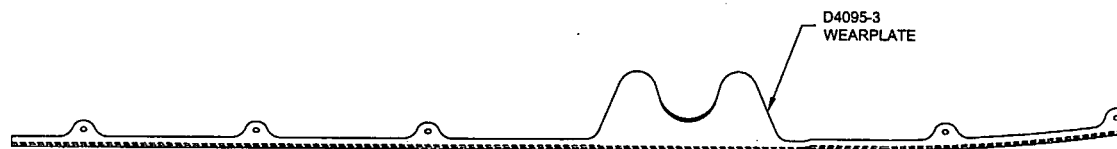
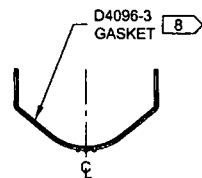
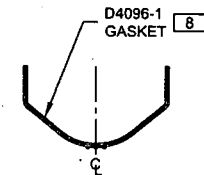
PRELIMINARY ISSUE  
10.04.22

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4095	REV. PA2
MFG. APPR.		SHEET 3 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	10.04.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D4095-041	WEARPLATE ASSEMBLY
2		X	D4095-043	WEARPLATE ASSEMBLY
3	1		D4095-1	WEARPLATE
4		1	D4095-3	WEARPLATE
5	1		D4096-1	GASKET
6		1	D4096-3	GASKET
7	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE



**D4095-041 WEARPLATE ASSEMBLY**



**D4095-043 WEARPLATE ASSEMBLY**

**RELEASED**  
2010-09-07  
NM

58022

**D4095-041/-043 NOTES:**

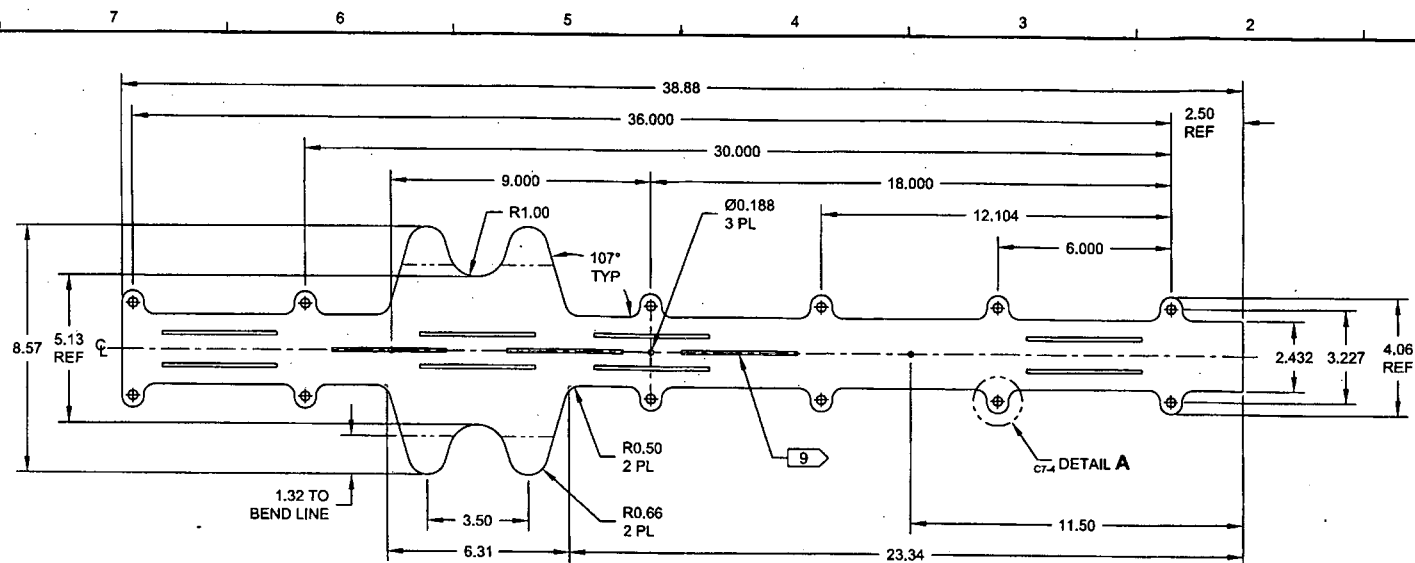
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-04X" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4095-041 = 2.60 lbs; D4095-043 = 2.58 lbs
- 8) AFTER FINISH, BOND GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 9) PARTS ARE SYMMETRIC ABOUT C

REV.	NEW ISSUE	DESCRIPTION	MB	10.04.20
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.04.20			

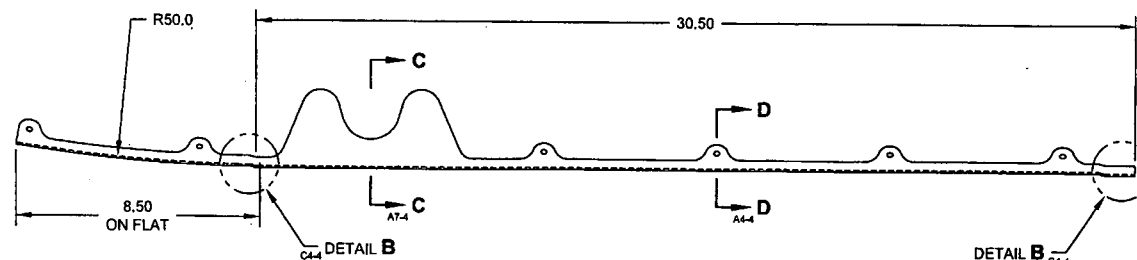
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4095  
REV. A  
SHEET 1 OF 4  
TITLE WEARPLATE  
SCALE NTS

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**D4095-1F FLAT PATTERN** 1



**D4095-1 BENDING DETAIL**  
(MAKE FROM D4095-1F)

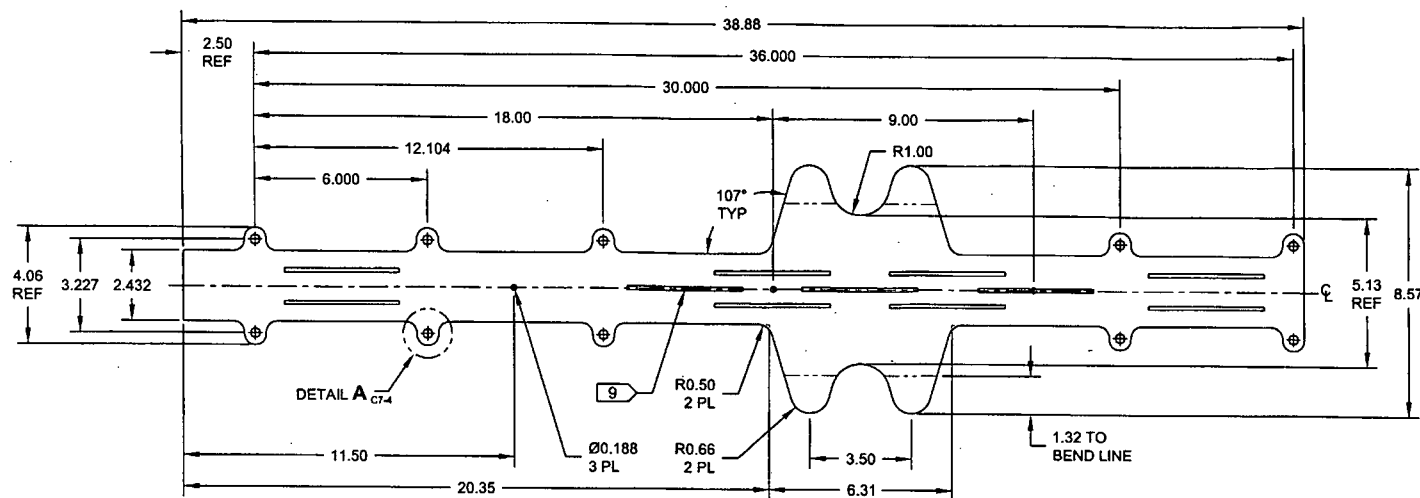
**D4095-1/-1F/-3/-3F NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240  
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 2.18 lbs; D4095-3 = 2.16 lbs
- 8) WELDING: PER DART QSI 004
- 9) 2059B HARDCOAT WELD: 4.0 LONG X 0.125 HIGH, 11 PL  
WELD AFTER BENDING AS ILLUSTRATED PER DT8308
- 10) PARTS ARE SYMMETRIC ABOUT C

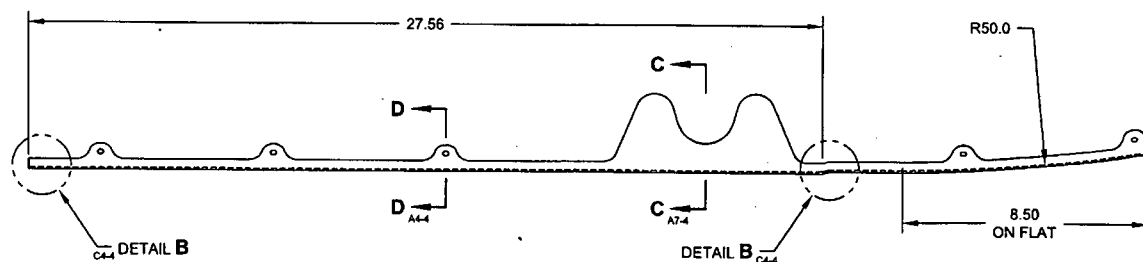
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DRAWN	1		
CHECKED	1	DRAWING NO.	REV. A
MFG. APPR.	1	D4095	SHEET 2 OF 4
APPROVED	1	TITLE	SCALE
DE APPR.	1	WEARPLATE	NTS
DATE	10.04.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
2010-08-07

58022



**D4095-3F FLAT PATTERN** 1

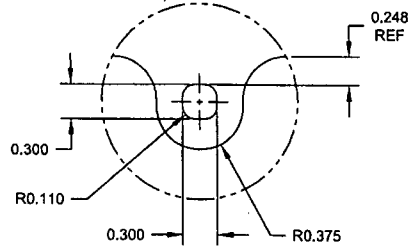


**D4095-3 BENDING DETAIL**  
(MAKE FROM D4095-3F)

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. /
MFG. APPR.		D4095	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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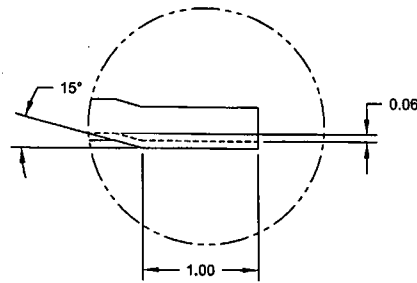
**RELEASED**  
2010-09-07  
VWD





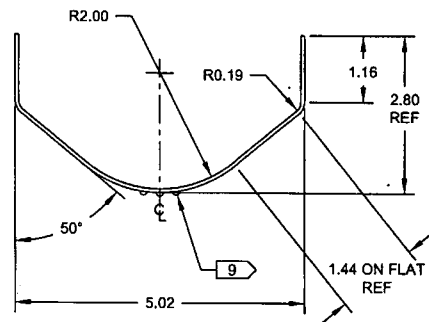
**DETAIL A: TAB DETAIL**

SCALE 4X  
C3-2  
C8-3



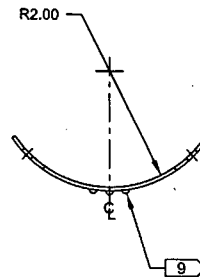
**DETAIL B: JOGGLE DETAIL**

SCALE 4X  
B2-2  
B5-2  
B4-3  
B7-3









**SECTION C-C**

SCALE 2X  
B5-2  
B4-3



**SECTION D-D**

SCALE 2X

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4095	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	10.04.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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58022  
**RELEASED**  
2010-09-07  
JMS

# Location/Lot Activity

October 7, 2010 1:32:50 PM

Page 1 of 1

Criteria : All Items All Locations Lot: 58022 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	D4095-1 / Wearplate	Main Warehouse	58137	FAUT01		2.0000		2.0000		
		ENG			4/27/10	-2.0000	58022	-2.0000		-\$202.41
								-2.0000		-\$202.41
WIP Receipt	D4095-1 / Wearplate	Main Warehouse	58022	FAUT01		0.0000		0.0000		
		ENG			4/27/10	2.0000	58022	2.0000		\$202.41
								2.0000		\$202.41